

# Work Order ID 70774

Wednesday, June 15, 2011 9:09:30 AM



Page 1

Item ID:	D3457-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Washer					
Start Date:	6/15/2011	Start Qty:	40.00			
Required Date:	6/22/2011	Req'd Qty:	40.00			
Reference:						

Approvals:	Process Plan:		Date:	6-06-15	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3457	Rev A

100		0.00						
	DOOSAN LATHE							
Doosan	Memo	0.00						
Doosan Lathe	Turn as per Folio FA589 Rev:  & Dwg D3457 Rev:							

2 11.6.22 40

110		0.00						
	QC2- Inspect parts off machine FAI/FAIB							
QC	Memo	0.00						
Quality Control								

2 11.6.22 40

120		0.00						
	QC8- Inspect parts - second check							
QC	Memo	0.00						
Quality Control								

11/6/23 40

**Work Order ID 70774**

Wednesday, June 15, 2011 9:09:30 AM



Page 2

Item ID: D3457-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 6/15/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: _____	0.00							
Packaging 	Memo 059	0.00						11/6/23	(40)
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC 	Memo	0.00							
Quality Control									

11/6/23  
MF  
11-06-23

# Picklist Print

Wednesday, June 15, 2011 9:09:37 AM

Page 1

Work Order ID: 70774

Parent Item: D3457-1

Parent Item Name: Washer



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A ☐ 05.10.03 ☐ New issue ☐ KJ/JLM ☐  
IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELNR1.000		Purchased	No			100	f	6.8000	0.0208	0.875789			
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Delrin Round Bar 1"



Re 11.6.22

Location

Loc Qty

Loc Code

MAT055

6.8

117985

6.8

1.333



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

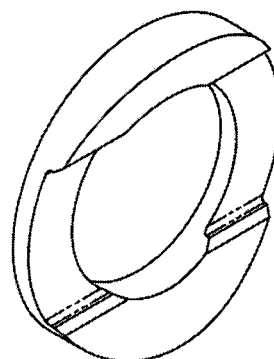


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

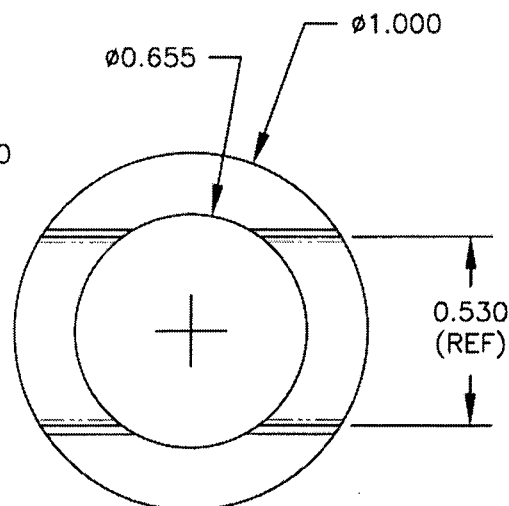
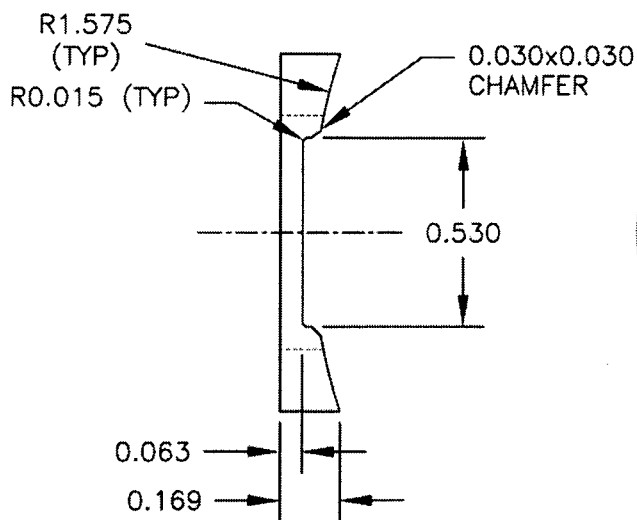
RELEASED  
05.09.06

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70774

PH-06-15



ISOMETRIC DETAIL



**D3457-1 WASHER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries